Work Order ID 119944

May-30-14 8:43:14 AM

119944

Item ID: D4628-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Liner, Outboard **Stop** *NS2*

Start Date: 5/30/14 **Start Qty:** 1.00 *1*

Required Date: 5/30/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MCJ **Date:** 14-05-30 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4628	A								
100		0.00							
100						1	0		JM14-05-30
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per dwg D4628 Prog rev: D Dwg rev: A 2-Deburr as per dwg								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						1	0		JM14-05-30
QC	**Memo**	0.00							
Quality Control									

Item ID: D4628-5 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Liner, Outboard

Start Date: 5/30/14 **Start Qty:** 1.00 *1*
Required Date: 5/30/14 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00 AS 27 -89							
120 QC Quality Control	**Memo**	0.00 14/5/30							
130	Identify as per dwg & Stock Location:_____	0.00							DAS 32 9-89
130 Packaging Packaging	**Memo** PPP119912	0.00				14/6/2 (1)			
140	QC21- Final Inspection - Work Order Release	0.00							
140 QC Quality Control	**Memo**	0.00				MCJ 14-06-03			MF 14-6-02

Picklist Print

May-30-14 8:43:17 AM

Work Order ID: 119944

119944

Parent Item: D4628-5

D4628-5

Parent Item Name: Liner, Outboard

Start Date: 5/30/14 **Required Date:** 5/30/14

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP RevA 12.03.29 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-52068		Purchased	No			100	sf	2,739.000	6.63	7			

MKYD6185S.080-P3-52068

Kydex steel grey (52"x96"-.080)

**

JM 14-05-30

Location	Loc Qty	Loc Code	
therm	2739		
119476	61		
121902	909		
122181	1075		122181
m127759	347		
m128321	347		

DART AEROSPACE LTD	Work Order:	119944
Description: Liner, Outboard	Part Number:	D4628-5
Inspection Dwg: D4628 Rev: A		Page 1 of 1

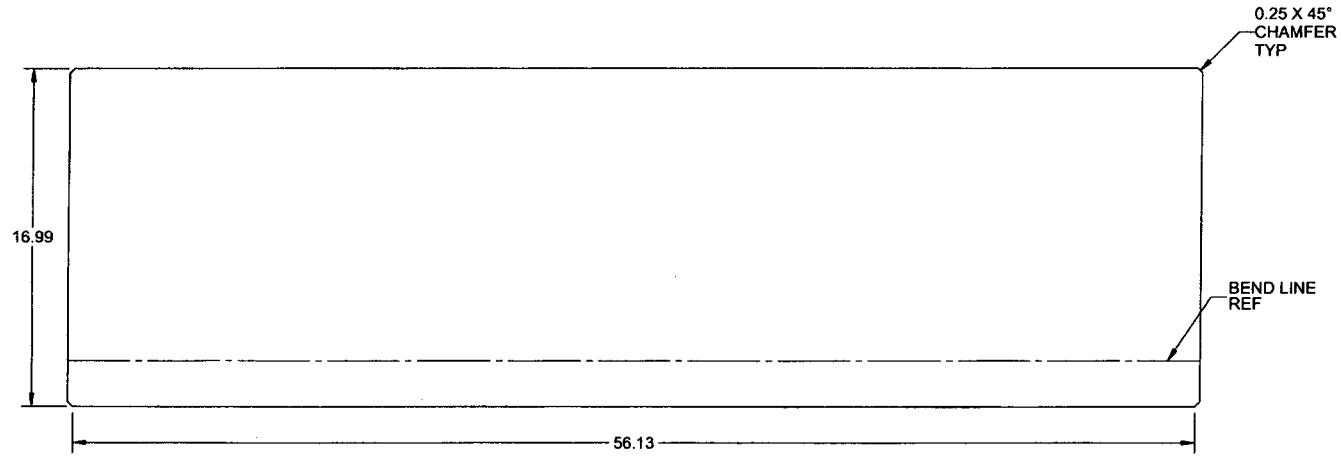
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.99	+/-0.030	16.99"	–		T	JHM05
56.13	+/-0.030	56.13"	–		T	
0.080	+/-0.010	0.080"	–		✓	JHM05

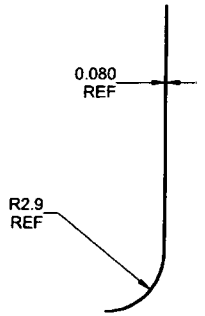
Measured by:	JM	Audited by:	27	Preliminary Approval:	
Date:	14-05-30	Date:	14/5/30	Date:	

Rev	Date	Change	Revised by	Approved
A	12.05.15	New Issue	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 11 09944 MLO
14-05-30



D4628-5 LINER, OUTBOARD



D4628-5 LINER, OUTBOARD
FORMED DURING ASSY
REF ONLY

RELEASED
2012-04-04

NOTES:
1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERED) OR STEEL GREY(ALTERNATE) COLOR, 0.080 THICK
REF. DART SPEC. MKYD6185S.080-P3-62000 OR MKYD6185S.080-P3-52068
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-5" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
7) WEIGHT: 3.35 lbs

DESIGN		**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	ASS	DRAWING NO. D4628 — REV. A
MFG. APPR.		SHEET 3 OF 5
APPROVED		TITLE: LINER — SCALE: NTS
DE APPR.		
DATE 12.03.27		

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